

Date: Tuesday, 7/17/2007 2:00:28 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET ASSEMBLY
 Job Number : 33589
 Estimate Number : 11030
 P.O. Number : N/A Part Number : D2803042
 This Issue : 7/17/2007 S.O. No. : N/A Drawing Number : D2803 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : B
 Previous Run : 29392 Material : N/A
 Due Date : 7/31/2007 Qty: 10 Um: Each
 Written By : [Signature]
 Checked & Approved By : [Signature]
 Comment : Est F 05.03.30 MS21043-3 was MS21042L3 KJ/JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D28032

STA 84 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

STA 84 BRACKET

Pick:

Qty	Part Number	Description
1	D2803-2	Bracket

Batch

B33599 x 10 ✓

2.0

D28052

Stop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

STOP

Pick:

Qty	Part Number	Description
1	D2805-2	Stop

Batch

B 33600 / B 34033 (x10)

3.0

D2809

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description
1	D2809	Bushing

Batch

B34035

4.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2805-2 into arm as per Dwg D2803

ml 07/08/07 x10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/02/29	5	Split into green	SB	07/02/29	(7)		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Tuesday, 7/17/2007 2:00:28 PM
Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 33589

Part Number: D2803042

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/28 (+10)

3.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3

7 pcs - green M102316
3 pcs - white M105068

7x green
3x white

Mf 07/08/29

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Mf 07-08-29

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Press D2809 into arm as per Dwg D2803

Mf 07-08-29

9.0

AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN3C16A	Bolt	M102552

M102552

Mf 07-08-29

10.0

MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
2	MS21043-3	Nut	M105211

M105211

Mf 07-08-29

11.0

NAS1515H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
4	NAS1515H3	Washer	M105164

M105164

A/R LPS-3 Corrosion Spray M104929
Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2803

M104929

Mf 07-08-29

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 33589

Part Number: D2803042

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D2803.

mf

07-08-29

13.

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/08/29 (77)

14.

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: GA

mf

07-08-30

15.

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/08/31

Job Completion

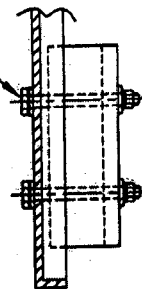


07-08-31

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE	04.11.22			TITLE STA 84 BRACKET	SCALE 1:3

AN3C16A BOLT (1)
NAS1515H3 WASHER (2)
MS21043-3 NUT (1)
INSTALL BOLT WITH LPS-3 CORROSION
INHIBITOR (ENSURE NO LPS-3 ON THREADS)
(2 PLACES)



SECTION D-D
SCALE 1:3
(ROTATED)

USE D2803-1 FOR D2803-041/-043
USE D2803-2 FOR D2803-042/-044

USE D2805-1 FOR D2803-041
USE D2805-2 FOR D2803-042
USE D2805-3 FOR D2803-043
USE D2805-4 FOR D2803-044
PRESS INTO PLACE PRIOR TO POWDER COAT

PRESS D2809 INTO PLACE
PRIOR TO POWDER COAT

SHOP COPY
RETURN TO

RELEASED

05-03-11

ENGINEERING
CONTROLLED C
SUBJECT TO AMEND
WITHOUT NOTIC
WORK ORDER
NO. 3358

D2803-041/-043 BRACKET ASS'Y (SHOWN).
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6 FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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